

REPLACEMENT PARAGRAPH PAGE 5, 5th FULL PARAGRAPH

Fig. 7 and Fig. 8 show in section and in side view, respectively, the tangential roll forming of a workpiece 1 between a profiled roll forming tool 6 and a rolling arbor 7. The arrows shown with solid black tips (in a longitudinal direction of the page) show the pressure of the tools 6 and 7 on the workpiece 1. The pressure acts radially. The arrows with the blank tips (in a transverse direction of the page) show the primary direction of the material flow. The material flow is tangential in respect to the surface line or the circular center core of the workpiece 1 illustrated in Fig. 8. Characteristic for the tangential roll forming is the enlargement of the workpiece diameter. In addition, the ~~shoulder~~ shoulder height of the workpiece 1 decreases.